Work Order ID 123732 *123732* Page 1 Monday, August 18, 2014 2:38:13 PM Item ID: D3574-2 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Cabin Floor Protector **Start Date:** *9* 8/13/14 Start Qty: 2.00 **Cust Item ID:** Required Date: 8/18/14 **Req'd Qty:** 2.00 *9* **Customer:** Reference: Start Run Process Plan: ______ **Approvals:** Date: 14-01-20 Tooling: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID Description Run Hours** Code Qty Stamp **Oty** Number **Draw Nbr Revision Nbr** D3574 Rev B 100 0.00 FLOW WATER JET *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3574 Dwg Rev: 🔑 Prog Rev:_ **B** 2-Deburr 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* QC

0.00

Memo

Quality Control

DQA:			Date:			WORK ORDER NON		21.50	D. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4.				DART
QA Closed:			Date:			WORK ORDER NON	-C(JNFOI	RIVIANCE / U		Work Order u	ndate only	AEROSPACE
,						DISPOSITION			r , v		DEPARTMENT		
Work Orde	er: _									AGAINST I		/PROCESS	
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۱٥					Scrap		1	Machining	Small Fab		d. Eng. Coor.	Quality
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	Щ°	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Щ	Cracks				Broken/Damage/Defect	L	Hardwa	ire		Part Incorre	ct	Temperature/Cure
	LJ ⁽	Crimp/Kir	ık/Ripple	/Wave	L	Burrs		Inspecti	ion Incomplete/U	nqualified	Part Lost/M	issing	Weld
	Ц̈́	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
	∐'	Crushing				Countersink		Misalig	ned/off center		Positioned \	Vrong	
		Heat Trea	t			Cut Too Short		Mislabe	eled	Γ	Power Loss/	Surge	Other
		nspectio	n Strip in	Tube		Drawing		Misread	t				
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of 0	Calibration				
	, I	Wave/Tw	ist in Tub	e e		Fit/Function		Out of s	Sequence				

Work Ord Monday, Augus				*123	3732*							Page 2
Item ID: Revision ID:	D3574-2			Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Cabin Floor	Protector								Stop	*//	S2*
Start Date:	8/13/14	Start Qty: 2.00	*2*		Cust Item]	ID:						. ,,
Required Date	: 8/18/14	Req'd Qty: 2.00	*2*	•	Customer:							
Reference:			•									
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej		Reject Number	Insp. Stamp
120		QC8- Inspect parts - seco	and check	0.00								38
120		Memo		0.00				(2)	- –			9-89 14-/
Quality Control												
130				0.00								
130 Small Fab		Small Fab	1	0.00								
Small Fab		Deburr if ne	cessary.	K								
140		QC5- Inspect part compl	leteness to step on W/	0.00								
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Quality Control

DQA:			Date:										NA DT	
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	_			•		Rework]		Skid-tube	Crosstube	7	Water Jet	Engineering	
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is	1	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	۷o. <u> </u>					Suspected Unapproved]		Large Fab	Composite		Supplier		
Root					Desci	ription of work order update		l Initial	Act	ion	Sign &			
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	—	racks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorre	 	Temperature/Cure	
:		•	ık/Ripple	/Wave	ļ	Burrs	<u> </u>	1	ion Incomplete/Un	· -	Part Lost/M	- I	Weld	
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	\vdash	leat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge	Other	
	\vdash		n Strip in	l'ube	-	Drawing	<u> </u>	Misread						
		/larks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set						
		-	equence		<u> </u>	Finish Fit/Function	_	4	Calibration					
	ı IV	vave/Tw	ist in Tub	10	- 1	LEIT/EUNCTION	F	I Out of 9	Saguence					

Work Ord Monday, Augu				*129	3732*						Page
Item ID: Revision ID: Item Name:	D3574-2 Cabin Floor	Protector		Accept	*N900	<u>040</u>	100	ገ*	Setup Star	171	S1* S2*
Start Date: Required Date Reference:	8/13/14 e: 8/18/14	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust Item 1 Customer:	D:				I	. 7/
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):		ate:]	Run Star Sto	□ ^ \]	R1* R2*
Sequence ID/ Work Center 150	ID	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Nyggber 66 9-89	Insp. Stamp

160

QC21- Final Inspection - Work Order Release

0.00

0.00

160

Packaging

Packaging

Memo

Memo

0.00

Quality Control

14/10/16 At w 10.36

OCT 1 5 2014

Page 3

DQA:			Date:										NA DT	
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDA	ATE			A E R O S P A C E	
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION			,	AGAINST DE	PARTMENT	TMENT/PROCESS		
	•					Rework			Skid-tube Crosstube			Water Jet	Engineering	
Part N	١o.					Scrap			Machining S	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	No.					Suspected Unapproved			Large Fab Co	omposite		Supplier		
Root					Desci	ription of work order update		Initial	Action	 	Sign &			
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		Bending			-	Bend	\vdash	1	Program		Outside Dim	-	Pressure/Forced	
		Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain			Over/Under		Set-up	
		Cracks			_	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	 	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave	_	Burrs	<u> </u>	•	ion Incomplete/Unqua	—	Part Lost/Mi	ssing	Weld	
	-	Cuffs				Contamination	<u> </u>	1	tions Incomplete/Uncle	ear	Part Moved	L	Wrong Stock Pulled	
		Crushing				Countersink	<u> </u>	-} ~	gned/off center	<u> </u>	Positioned W		7	
	_	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other	
		Inspection	•	Tube		Drawing	<u> </u>	Misread						
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes	<u></u>	Off-set						
	L	Turning S	•		-	Finish		1	Calibration					
	<u> </u>	Wave/Tw	ist in Tub	e		Fit/Function	L	Out of S	Sequence					

Picklist Print

Monday, August 18, 2014 2:38:12 PM

Work Order ID: 123732

123732

Parent Item:

D3574-2

D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 8/13/14

Required Date: 8/18/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev : A New Issue 07-01-22 EC

Component Item ID/	Replacement	Mfg/	Bin

Item Name Item ID Purch

Primary Last Item Location Location

Route Seq ID

Unit of Measure Hand

Qty on

Qty per Kit Total

Qty

Qty

Date Issued Issued

Status

Page 1

MLEXS.125-F60029-04

Purchased

No

TPI

sf

699.6 2025 5,110.630

(51)

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location Loc Qty Loc Code **MAT019** 2991.525 124866 106 m126425 160.925

m127934

m129759

2119.10588 2119.10588 **

DQA:		Date:			-							A DT
OA Classel.		Data			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE			, , , , , , , , , , , , , , , , , , , ,	AEROSPACE
QA Closed:		Date				-			W	ork Order up	odate only	
Work Orde	er:				DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS	
					Rework			Skid-tube Crosst	ube		Water Jet	Engineering
Part N	lo				Scrap			Machining Small	Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming Finisl	hing	1	re/Packaging	Other
NCR N	١٥				Suspected Unapproved			Large Fab Compo	site		Supplier	
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Cause	Da	te Step	Qty	Desci	or non-conformance	1	iief Eng	Action		Sign &	Verification	OC Inchastor
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Landir	ng Gear				General							
	Bend	ing			Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
	Centi	e Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Crack	S			Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure
	Crim	o/Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
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ļ	—	Treat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	_	ction Strip ir	1 Tube	<u> </u>	Drawing		Misread	<u>'</u>				
	—	s/Chatter			Drill Holes		Off-set					
		ng Sequence		<u> </u>	Finish		1	Calibration				
	Wave	/Twist in Tu	be		Fit/Function	1	Out of 9	Sequence				

DART AEROSPACE LTD	Work Order:	123732
Description: Cabin Floor Protector	Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2

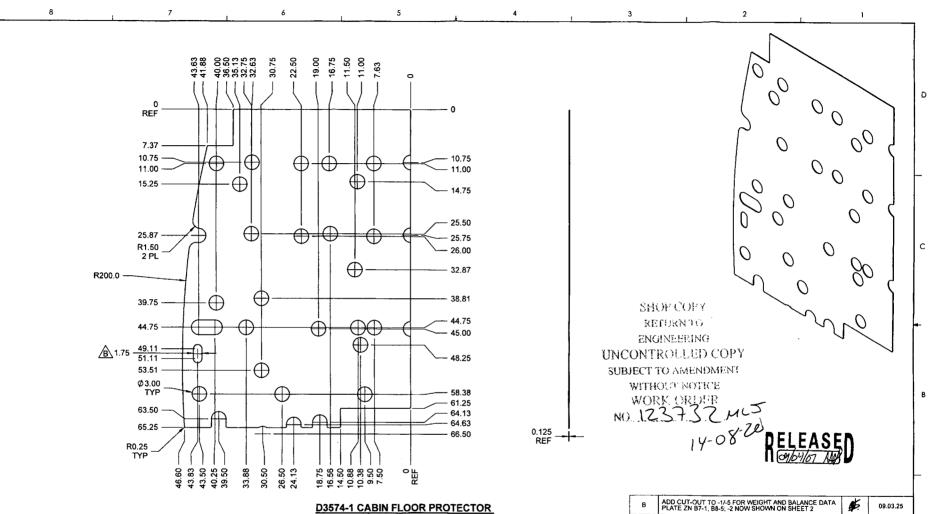
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	21.50	1		V=JKM-0'	
30.50	+/-0.030	30.50	1		1=5KM-06	
33.88	+/-0.030	33.88	/			
39.50	+/-0.030	39.50	/			
40.25	+/-0.030	40.25				
43.50	+/-0.030	43.56				
46.60	+/-0.030	46.60	1			
			7			
7.63	+/-0.030	7.63	/			
11.00	+/-0.030	ULUU				
11.50	+/-0.030	11.50				
16.75	+/-0.030	11.75				
19.00	+/-0.030	19.00				
22.50	+/-0.030	22.50	/			
30.75	+/-0.030	30-75	/			
32.63	+/-0.030	32.63				
32.75	+/-0.030	12:75	/			
35.13	+/-0.030	75.17				
36.50	+/-0.030	36.50	/			
40.00	+/-0.030	40.00				
41.88	+/-0.030	41.84	/			
43.63	+/-0.030	43.63	7			
0.125	+/-0.010	. 128	040			

Measured by:	DL (200	Audited by:	Prototype Approval:	N/A
Date:	14/10/15	Date: 19-10)-/6 Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue	KJ//DD	
В	08.07.31	47.75 dimension removed	KJ/DD ,	
С	09.05.15	Dimensions updated per Dwg Rev B'	KJ 94	T. T.

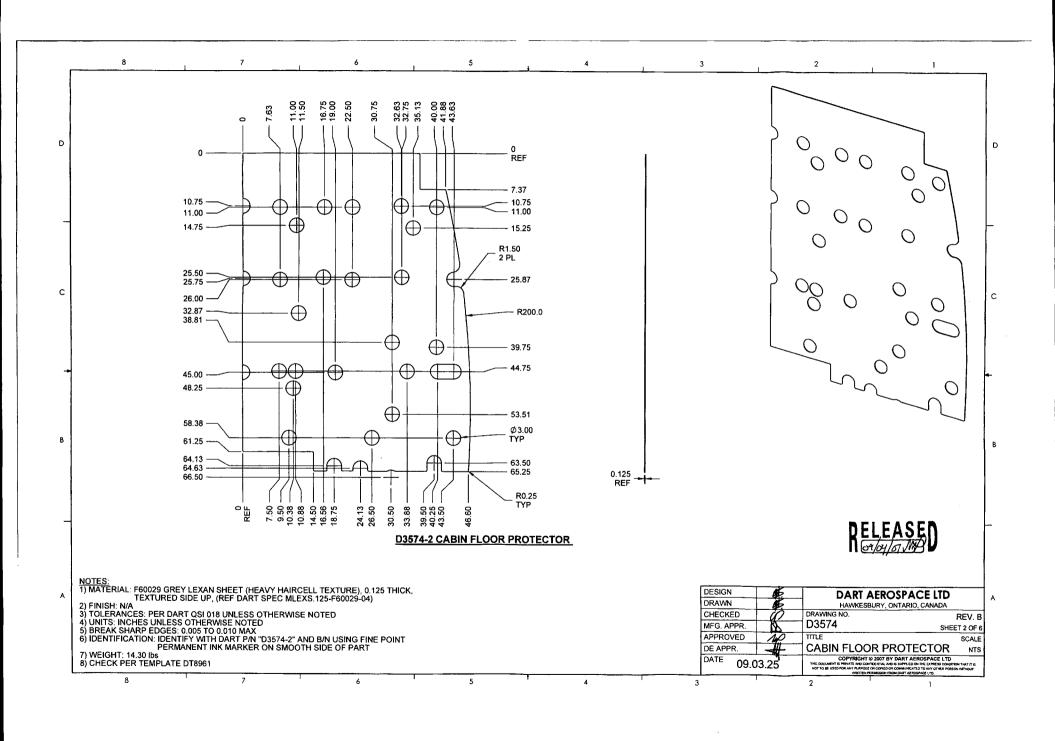


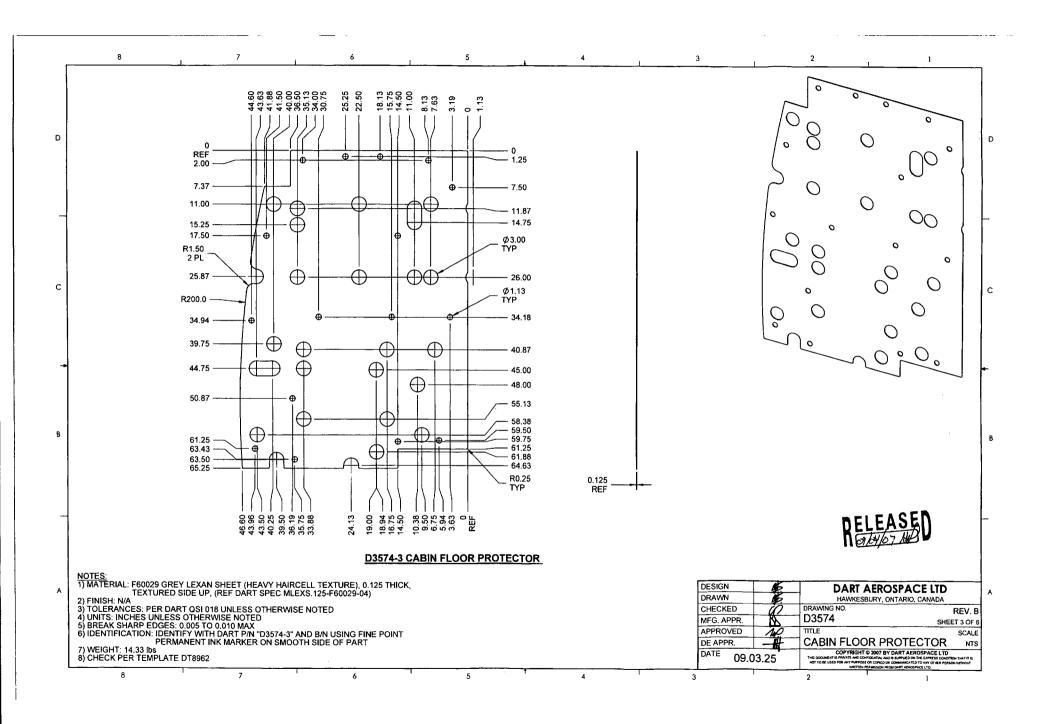
-		Α	NEW ISSU	JE			СВ	07.0	6.08
١	NOTES:	REV.				DESCRIPTION	BY	DA	TE
	1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,	DESIGN		-	į.	DART AEROS	PACE	TD	
1	TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04) 2) FINISH: N/A	DRAWN	I	d		HAWKESBURY, ONT			- /
-	3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	CHECK	ED	a	7	DRAWING NO.		R	EV. B
1	4) UNITS: INCHES UNLESS OTHERWISE NOTED	MFG. A	PPR.		Ĺ_	D3574		SHEET	1 OF 6
	5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT	APPRO	VED	14	0	TITLE			SCALE
١	PERMANENT INK MARKER ON SMOOTH SIDE OF PART	DE APF	R.	4	#-	CABIN FLOOR PRO)TECT	OR	NTS
١	7) WEIGHT: 14.30 lbs 8) CHECK PER TEMPLATE DT8961	DATE	09.03	3.25	* 1	COPYRIGHT © 2007 BY DA THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS 22 HOT TO BE USED FOR ANY PURPOSE OR COPIED OR COM-	PPLIED ON THE EXPIR	ESS CONDITION T	

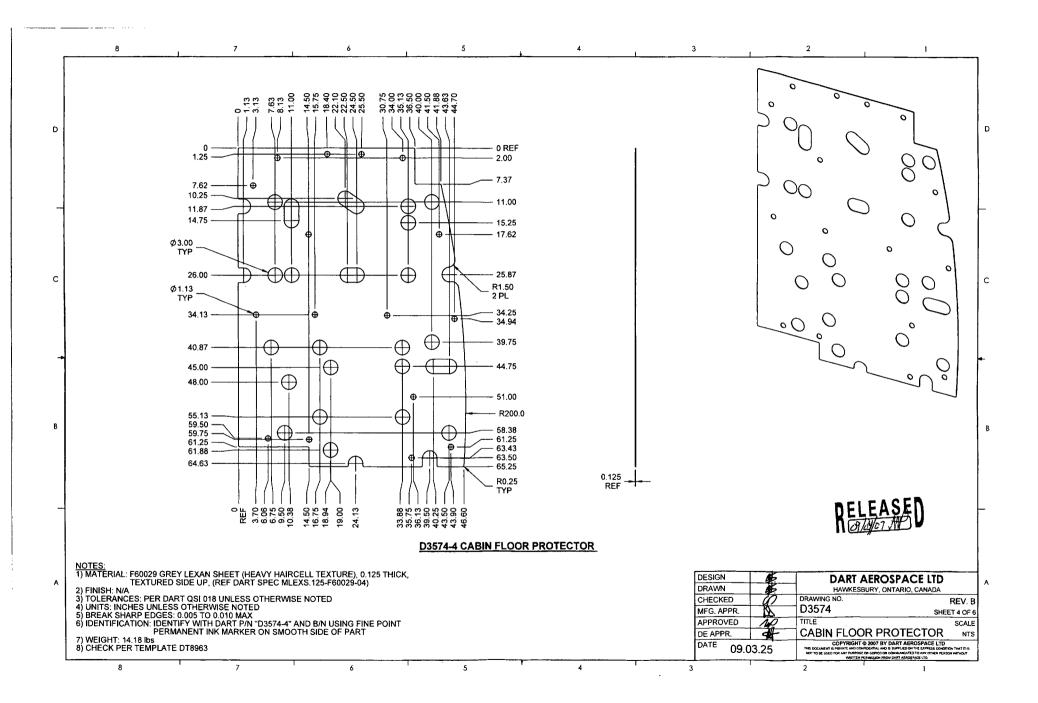
7) WEIGHT: 14.30 lbs 8) CHECK PER TEMPLATE DT8961

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43.63 41.88 40.00 36.50 35.13 7.63 1.13 D 0 D REF 7.37 11.00 - 11.87 - 14.75 15.25 R1.50 2 PL 25.87 - 26.00 Ø3.00 R200.0 -TYP 39.75 -40.87 \oplus 44.75 45.00 48.00 B 1.75 49.11 -55.13 58.38 58.38 61.25 - 61.88 63.50 64.63 65.25 0.125 REF R0.25 TYP 46.60 43.83 43.50 40.25 39.50 19.00 16.75 14.50 10.38 9.50 6.75 24.13 **D3574-5 CABIN FLOOR PROTECTOR** 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04) DESIGN DART AEROSPACE LTD 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART DRAWN HAWKESBURY, ONTARIO; CANADA DRAWING NO. CHECKED REV. B D3574 MFG. APPR. SHEET 5 OF 6 TITLE APPROVED SCALE CABIN FLOOR PROTECTOR DE APPR. 7) WEIGHT: 14.38 lbs 8) CHECK PER TEMPLATE DT8964 COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PROVIDE AND CONFECUTION, MOST SUPPLIED ON THE IS EMPLIED ON THE ISSUED OF THE ISSUED O DATE 09.03.25 8 7

1. 1. 1

8 22.10 22.50 24.50 35.13 36.50 40.00 41.88 43.63 11.00 7.63 D REF 7.37 10.25 11.00 11.87 14.75 15.25 26.00 25.87 С R1.50 2 PL Ø3.00 TYP \oplus 39.75 40.87 \oplus 45.00 44.75 \oplus 48.00 - R200.0 55.13 - \oplus \oplus 58.38 61.25 61.88 63,50 64.63 65.25 0.125 R0.25 REF 6.75 9.50 10.38 14.50 16.75 19.00 RFO 33.88 39.50 40.25 43.50 46.60 **D3574-6 CABIN FLOOR PROTECTOR** NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04) DESIGN DART AEROSPACE LTD 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3574 MFG. APPR. SHEET 6 OF 6 APPROVED TITLE SCALE DE APPR. **CABIN FLOOR PROTECTOR** NTS 7) WEIGHT: 14.27 lbs 8) CHECK PER TEMPLATE DT8965 COPYRIGHT © 2007 BY DART AEROSPACE LTD DATE 09.03.25 7 8 5

4. 30.0